



Pregis

AirSpeed HC Belt Replacement and Drum Diagnostic Manual



Drive Belt Removal

1. Place the power switch in the OFF position remove the power cord from the plug.

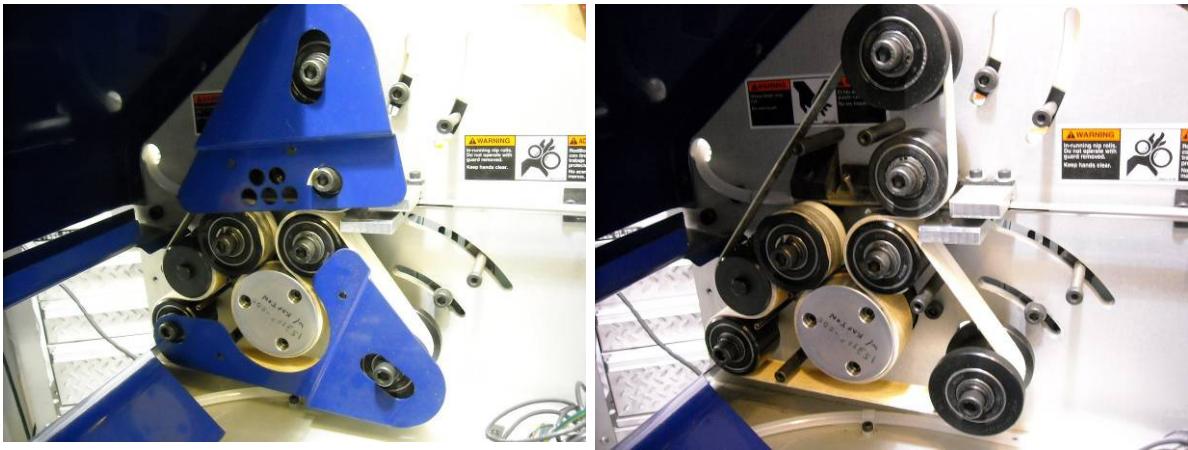


Electrical shock or unexpected machine movement can cause serious injury or death. For your safety, follow your company's lockout/tagout policy as required for each task.

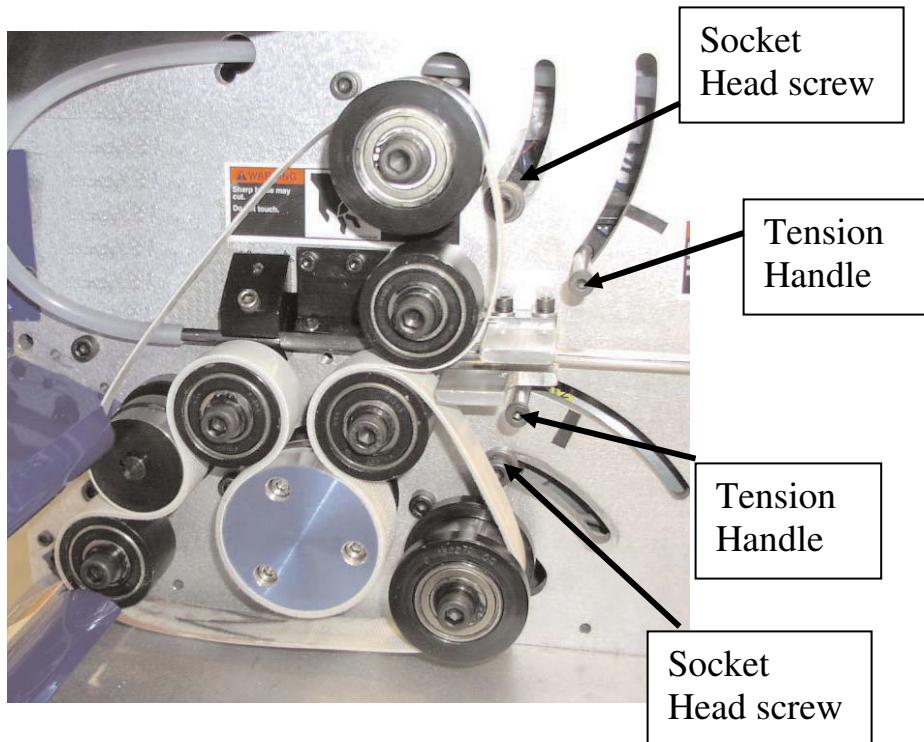
2. Lift the hood fully, lowering it back onto the cover guard.

NOTE: Additional access to the drive belts can be achieved by removing the outfeed cover guard with an Allen™ wrench.

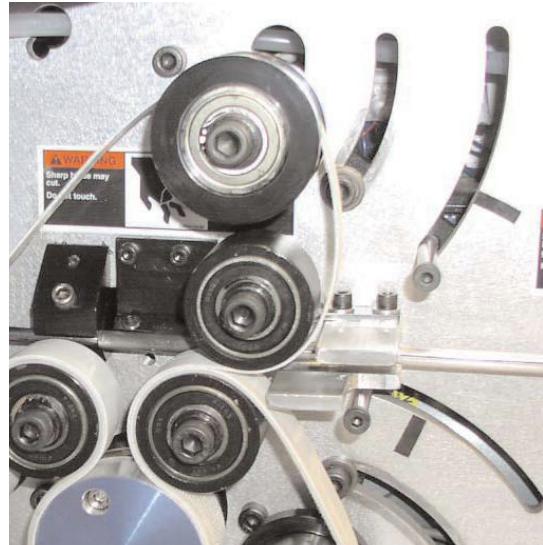
3. Remove the upper and lower belt guards



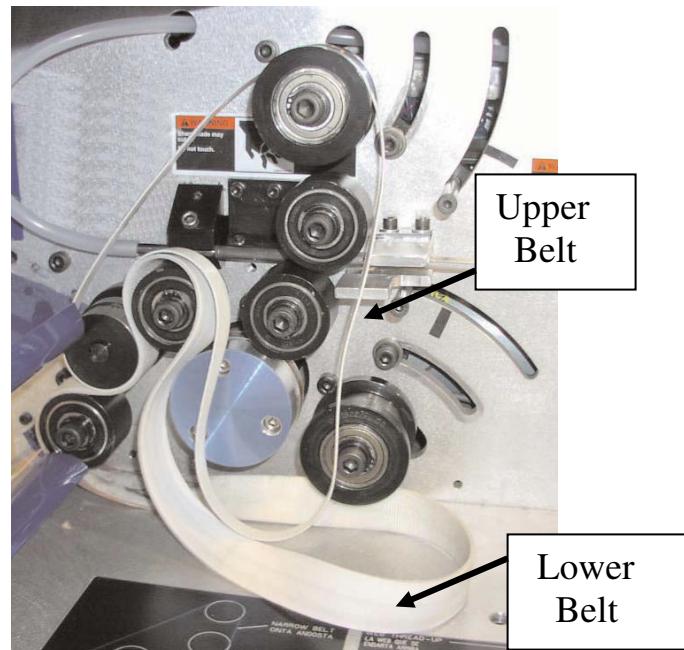
4. At the slots in the main plate, loosen the sockethead capscrews that



5. Push the tensioner handles towards each other removing tension from the belts.



6. First slide both belts off the sealing drum together and then continue to remove them from the remaining idlers and rollers

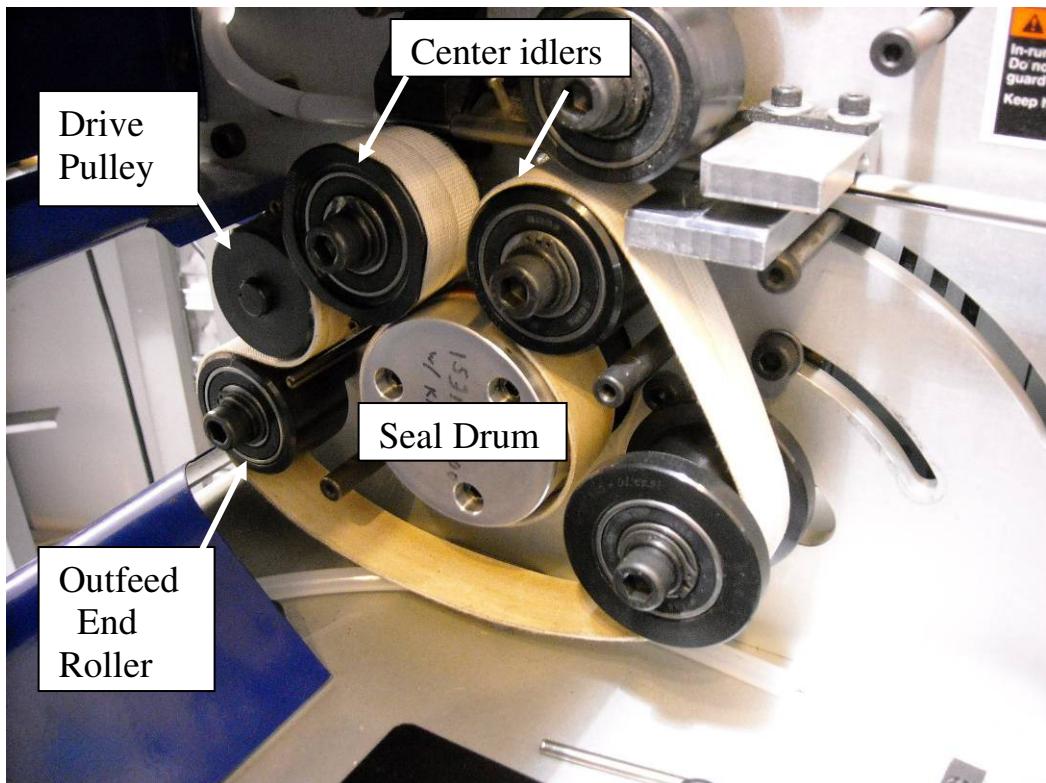


Drive Belt Installation



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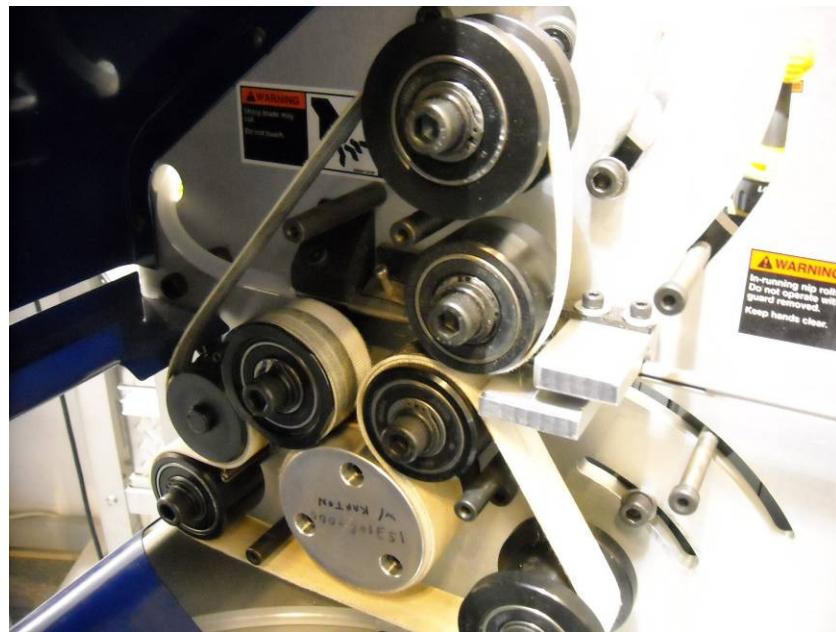
1. Place the power switch in the OFF position remove the power cord from the plug.
2. Install the wider, lower belt around the infeed end lower, flanged guide roller. Place the belt around the center idlers and sealing drum, finishing by placing the belt under the drive pulley and around the outfeed end idler. Place the smooth, Teflon-coated surface of the belt against the outside surface of the guide roller.



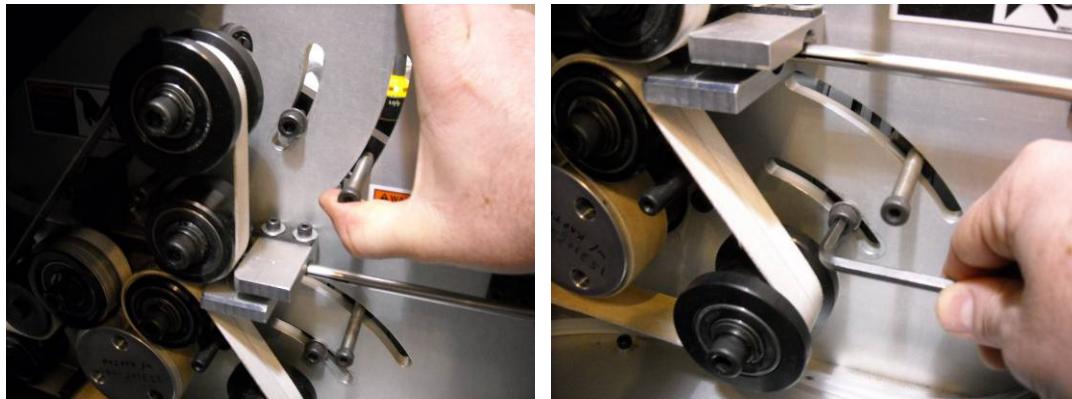
3. Install the narrower, upper belt around the infeed end upper, flanged guide roller. Place the smooth, Teflon-coated surface of the belt against the outside surface of the guide roller.



4. Place the belt around the upper idler and center idlers and sealing drum. Carefully tuck the upper belt into the gap between the lower belt and sealing drum. Finish by placing the upper belt under and around the outfeed end drive pulley



5. Apply a slight amount of tension to each of the tension handles and tighten the socket head screw.



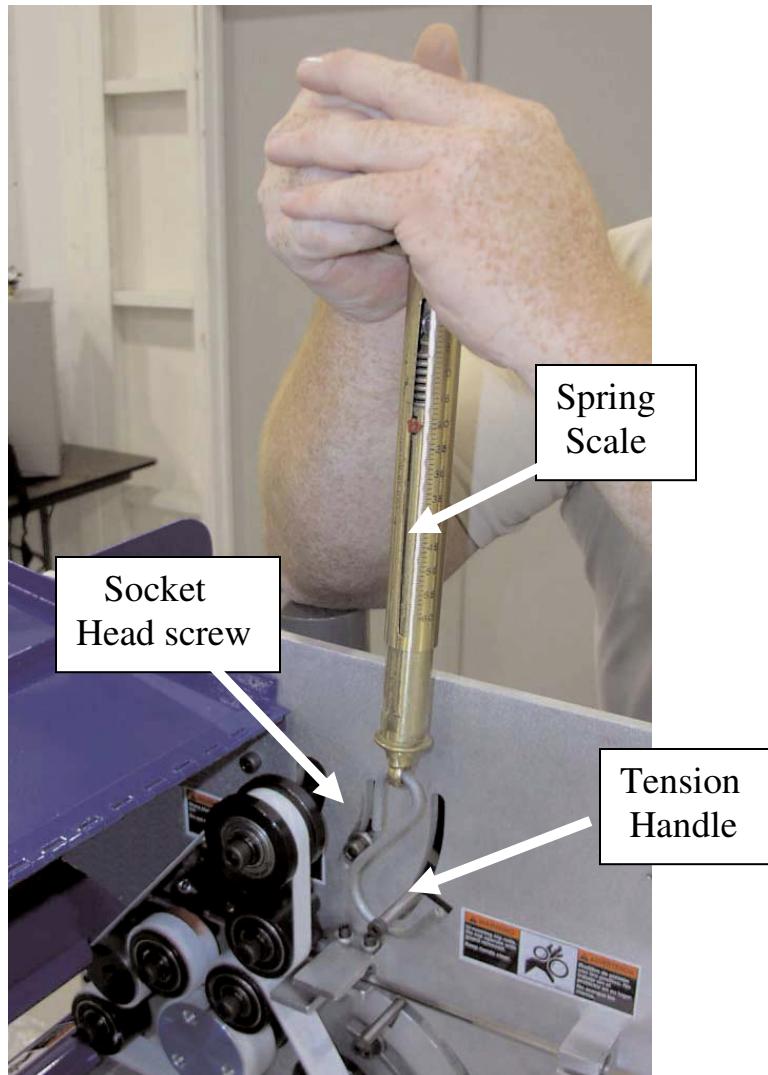
6. Apply power to the machine.
7. Jog the machine for 30 seconds to align the belts



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8. Place the power switch in the OFF position remove the power cord from the plug.

9. Loosen the socket cap screw to loosen the tension on the upper and lower belts.
10. Pull the upper tensioner handle upward with a spring scale until a reading of 25 lbs. of force is applied to the belt. Hold the tension on the handle while tightening the sockethead cap screw to lock it in place.



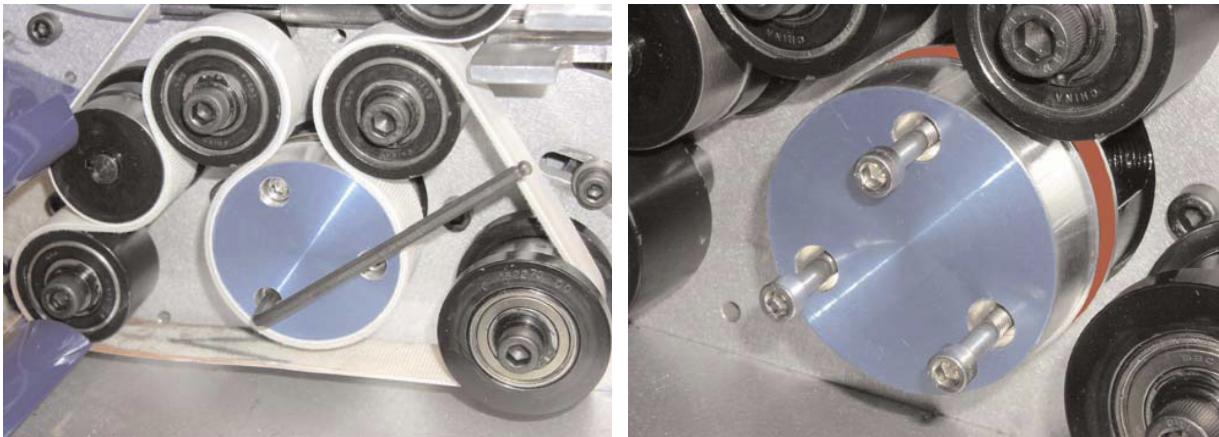
Do not try to move the belts while jogging or running. Exposed nip points could injure the operator.

Seal Drum Replacement



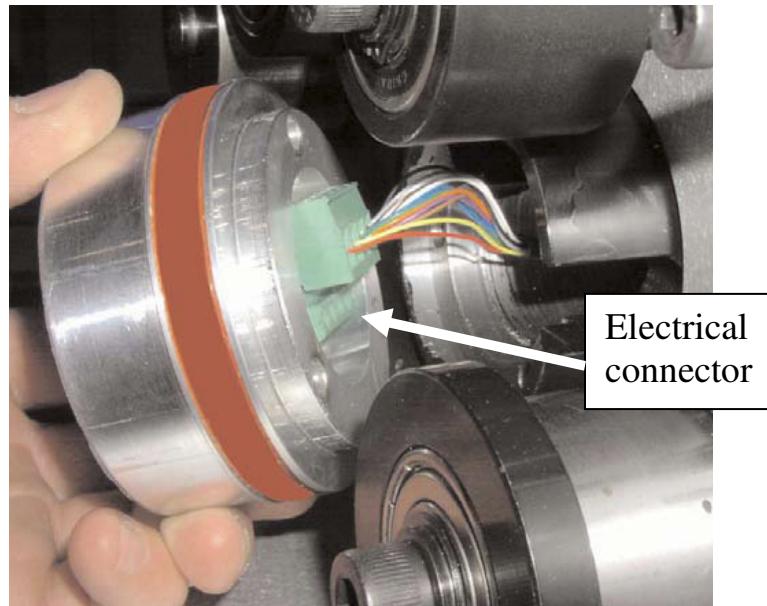
Electrical shock or unexpected machine movement can cause serious injury or death. For your safety, follow your company's lockout/tagout policy as required for each task.

1. Place the power switch in the OFF position and remove the power cord from the plug.
2. Lift the hood fully, lowering it back onto the cover guard.
3. Loosen the three (3) sockethead cap screws from the face of the sealing drum hub.
4. Remove the three (3) sockethead cap screws from the face of the sealing drum hub.

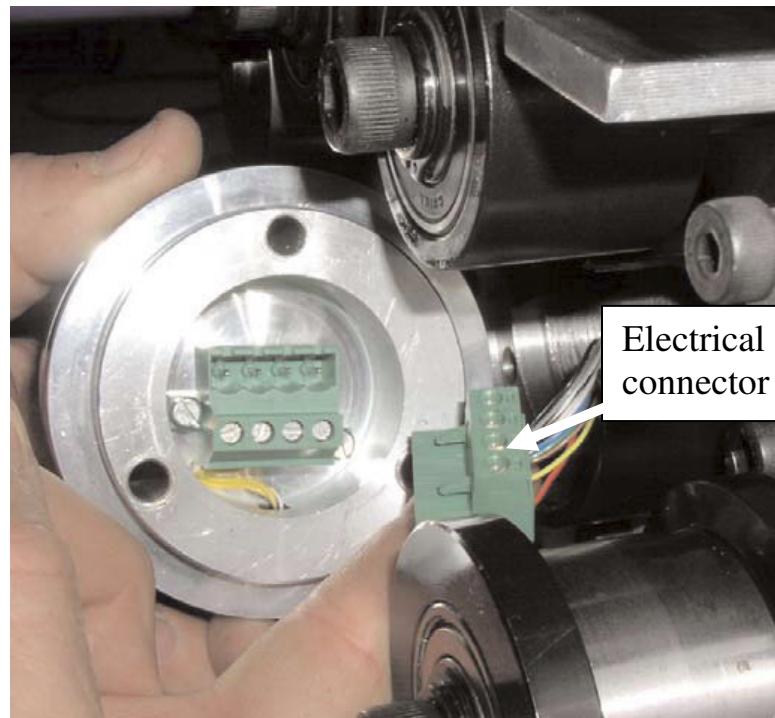


5. Remove the upper and lower drive belts. Refer to the *Drive Belt Replacement* instruction.

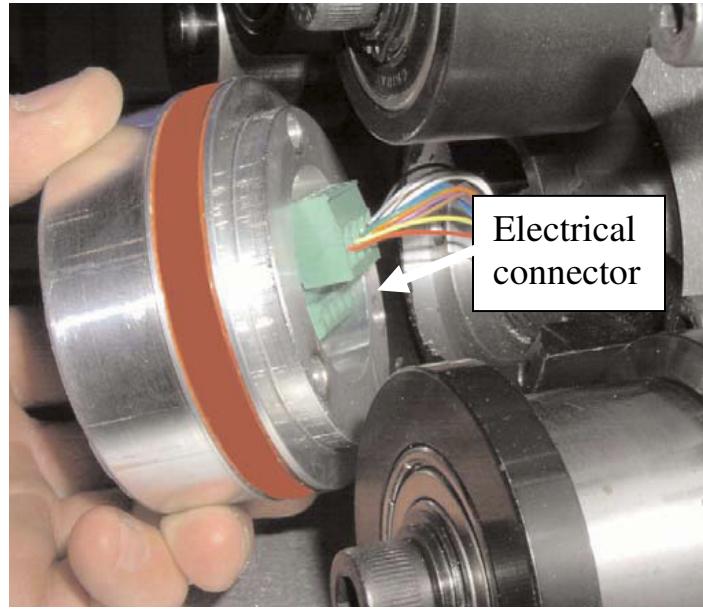
6. Grip the drum hub and carefully pull it outward off the sealing drum axle.



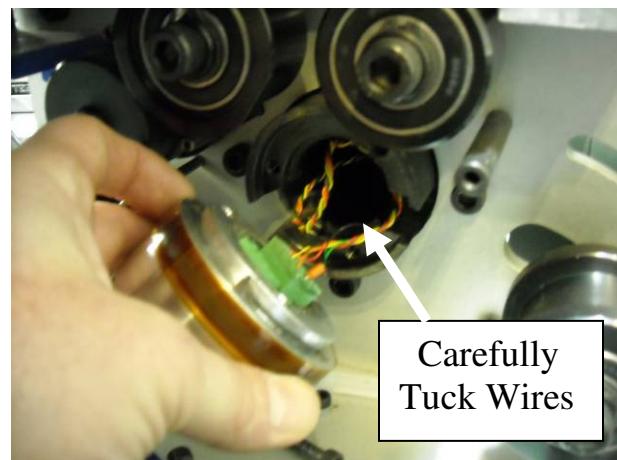
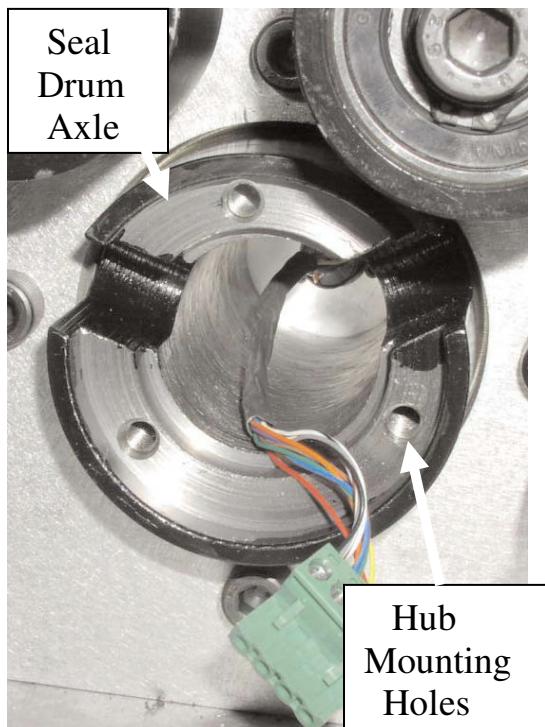
7. Turn the hub over and unplug the electrical connection on the inside of the hub.



8. Secure a new replacement drum.
9. Plug the electrical connector extending from the sealing drum axle into the inside of the drum hub.



10. Carefully tuck the wires into the hollow axle shaft as you insert the drum onto the end of the axle.



11. Line up the three holes and install the three socket head cap screws through the face of the sealing drum hub and into the mating holes in the end of the axle. Turn cap screws in fully, but do not tighten.

12. Install the upper and lower drive belts. Refer to the *Drive Belt Replacement* instruction.

NOTE: The drive belts tension is used to hold the sealing drum hub stationary while the mounting screws are tightened.

13. Tighten the mounting cap screws in an alternating pattern so that the hub is pulled on the axle evenly.

14. Place the power switch in the ON position and install the power cord from the plug.

Seal Drum Diagnostics

There are many causes of drum failure on the AirSpeed HC machine. The following steps should be completed any time a drum failure or seal failure occurs.

Symptoms:

- * No seal appears on final HC product
- * Intermittent seal appears on final HC product
- * “Open Seal Wire” error message on the display
- * AirSpeed HC Machine blows main fuse or seal drum fuse located on the din rail

NOTE: The in-service date, machine KM reading and the removed from service date must be recorded for each drum and forwarded along with the failed drum to Brett Christeon.

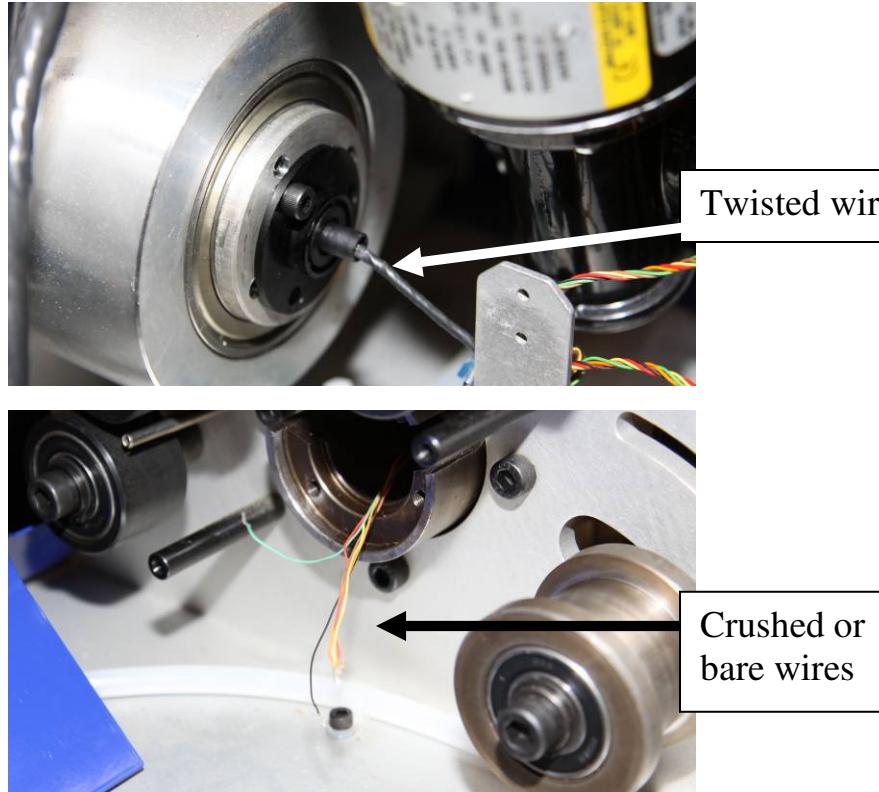
Drum Failure Diagnosis

1. Remove the seal drum and do a visual inspection. Check to make sure that there are no burn marks on the seal drum. If a burned area is observed, the seal drum has failed.
2. Do a continuity check of the seal wire on the drum using a multi meter. Check across the two red wires then the two yellow wires. If an open circuit is found the seal drum has failed.



Note: Refer to step 4 for more information on checking for continuity>

3. Perform a visual inspection of the wires on the slip ring for crushed or twisted wires that may lead to a short or split wire. If a damaged wire is found, replace the slip ring.

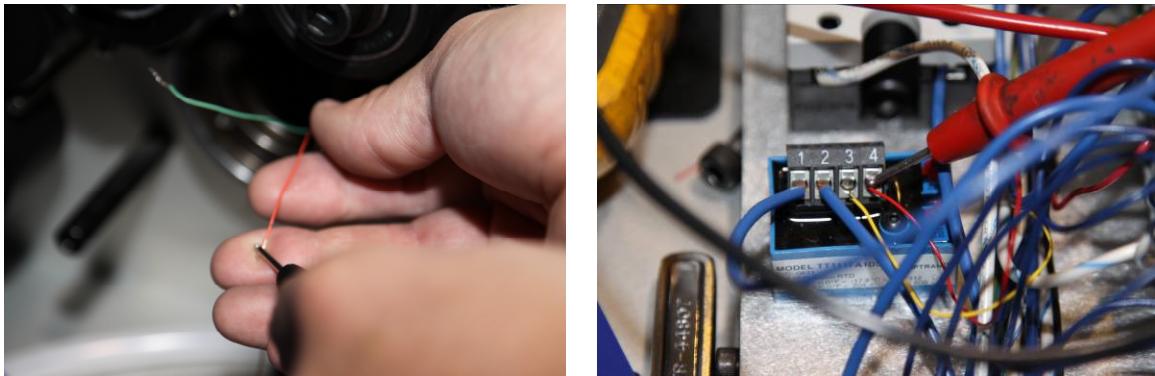


4. Check all 6 the wires in the slip ring for continuity or short. If continuity is not found or a short is found in any wire, replace the slip ring.

Continuity check:

- A. Use your multi- meter to complete this check by placing the meter into the continuity setting.
- B. Place one lead from the meter to each end of the wire. The meter should read “0” if continuity is found. If continuity is not found the screen will display “O.L”. If the Audio setting is used, a beep will be heard when continuity is present.





NOTE: Remove both wires from terminal and test each wire individually.

Short to ground check:

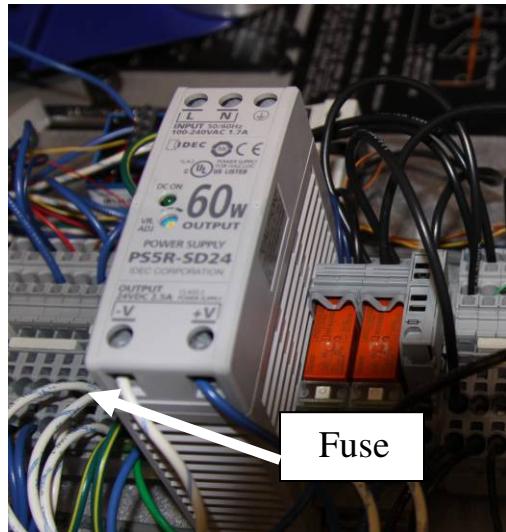
- A. Use your multi- meter to complete this check by placing the meter into the continuity setting.
- B. Place the lead from the meter on the wire then touch the other lead to the chassis of the machine. If continuity is found between any wire and the chassis (ground) of the machine, replace the slip ring.



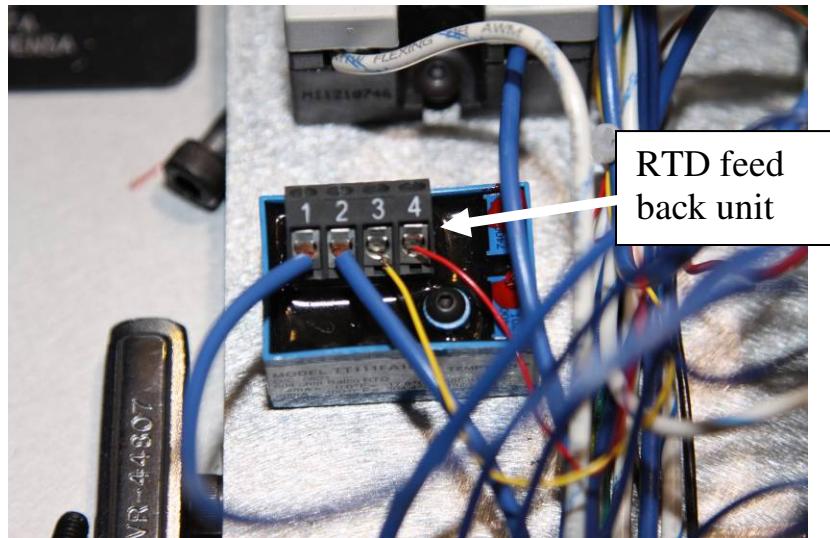
NOTE: Remove both wires from terminal block and Solid State relay terminal and test each wire individually.



4. Check the Seal fuse located just to the left of the power supply. If the fuse is blown it will need to be replaced



6. If the seal drum fuse has blown, the RTD feed back unit will need to be replaced. If the RTD unit has failed and is not replaced, the HMI may read "High Feed back" or "Low Feed back" or lead to another drum failure.



7. Connect all wiring connections that may have been disconnected during this process.
8. Install seal drum and belts. Follow directions labeled *Seal Drum Replacement*.

9. Power on AirSpeed machine and test unit by running material and checking seal integrity.